

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018521**Date Inspected:** 28-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (Lift 11W)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the cope hole located at the floor beam to bottom panel, floor beam to side panel and at longitudinal diaphragms to verify the radius and smoothness using 150mm rule. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Lift 11W - PP 95, PP 98, PP 101, PP 104 and PP 107

OBG # TRIAL ASSEMBLY YARD (Lift 11W)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the reentrant corners located at the floor beam vertical flange welded on the flange of longitudinal diaphragm to verify the radius using pre-cut 25mm and 50mm template. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Lift 11E - PP 95, PP 98, PP 101, PP 104 and PP 107

OBG # TRIAL ASSEMBLY YARD (11EE-12AE)

This QA Inspector along with QA Inspector Mr.Manjunath S Math performed dimensional joint survey inspection on the U rib to verify the offset using 1000mm straight edge. The measurements were recorded on a separate sheet and forwarded to team leader for review and disposition. The segment and panel point designations were as follows:

Segment 11EE to Segment 12AE – PP 108 to PP 109

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11DE-11EE)

The QA Inspector observed the welding operation per the SMAW process on base metal in the (4G) overhead position on side and bottom panel. The location were the base metal damaged on skin plates from welding fixtures removal near transverse splice weld joint of segment 11DE and 11EE at bike path side. The welder ID was 040724. The welding was performed against critical welding repair report B-CWR1957. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD (11DW-11EW)

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 007 in the (4G) overhead position on side panel piece mark no. OBW11C. The location was the transverse splice weld joining segment 11DW and 11EW at counterweight side. The welder ID was 040611. The welding was performed against critical welding repair report B-CWR2272 Rev.0. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F)-FCM-Repair-1.

OBG # TRIAL ASSEMBLY YARD

The QA Inspector observed the welding operation per the SMAW process on weld joint no. 093 and 094 in the (4G) overhead position on runner blade plate piece mark no. SSD12A-PP106. The welder ID was 040611. The welding variables recorded by QC appeared to comply with the WPS-B-P-2314-Tc-U4b-FCM-1.

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 006 in the (1G) flat position on Traveler rail bracket piece mark no. TR1C-PP108. The welder ID was 049220. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

The QA Inspector observed the welding operation per the FCAW process on weld joint no. 006 in the (1G) flat position on Traveler rail bracket piece mark no. TR1B-PP095. The welder ID was 053486. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-ESAB.

For additional information please reference the pictures below:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
